

Work Order ID 90779

Monday, September 24, 2012 2:27:09 PM

90779

Ship tomorrow

Page 1

Item ID: DSI 9631-011 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Vibration Isolation Installation
 Start Date: 9/24/2012 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 9/24/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: MF Date: 12-09-24 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI 9631	A

100 DOCUMENT CONTROL 0.00
 100
 DC Memo 0.00
 Document Control Photocopy bluefile & type labels per PPP DSI9631-011 CHG001

110 Pick Kit 0.00
 110
 Packaging Memo 0.00
 Packaging

120 QC4- 100% Inspect kits for completeness 0.00
 120
 QC Memo 0.00
 Quality Control

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube <input type="checkbox"/></td> <td style="width:25%;">Crosstube <input type="checkbox"/></td> <td style="width:25%;">Water Jet <input type="checkbox"/></td> <td style="width:25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>																								
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																									
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector																		
Doc/Data <input type="checkbox"/>																											
Equip/Tooling <input type="checkbox"/>																											
Operator <input type="checkbox"/>																											
Material <input type="checkbox"/>																											
Setup <input type="checkbox"/>																											
Other <input type="checkbox"/>																											
Process <input type="checkbox"/>																											
Supplier <input type="checkbox"/>																											
Training <input type="checkbox"/>																											
Unapproved <input type="checkbox"/>																											

FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

Picklist Print

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Work Order ID: 90779

Parent Item: DSI 9631-011

Start Date: 9/24/2012

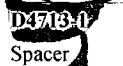



Required Date: 9/24/2012

Parent Item Name: Vibration Isolation Installation

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.10.24 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
8  D4713-0 Spacer		Manufactured	No			110	Each	0.0000	 0	B891836	sl		
5  MS3367-5-0 Tie Wrap		Purchased	No			110	Each	0.0000	 0	1	M123164	sl	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-797-2 Rev. B,
IIN-D407-797-1 Rev. B AND INSTRUCTIONS FOR
CONTINUED AIRWORTHINESS ICA-D407-797 REV. 1

REF CANADIAN STC: SH11-1

REF FAA STC: SR02996NY

REF EASA STC: 10035429

1.0 PURPOSE

REFERENCE ONLY

The purpose of this Dart Service Instruction (DSI) is to reduce potential vibration on the D3912-041 Eyebolt Receiver Assy. This DSI is applicable to D206-797-021/-022/-023/-024 Quick Release Heli-Utility-Baskets as well as D407-797-011/-012/-013/-014 Quick Release Heli-Utility-Baskets.

2.0 INSTALLATION

- 2.1 Remove the D4272-011/-012/-013/-014 Basket Assy from the aircraft in accordance with Section 25.1 of ICA-D407-797.
- 2.2 Install D4713-1 Spacer with the chamfer side facing inboard by forcing it over the D3912-1 Eyebolt (see Figures 1 & 2). Install MS3367-5-0 Tie Wrap over the D4713-1 Spacer (see Figure 2).
- 2.3 Re-install D4272-011/-012/-013/-014 Basket Assy per Section 25.2 of ICA-D407-797

3.0 MAINTENANCE

- 3.1 During the 300 Hour Inspection of the basket installation, check the physical integrity and security of the D4713-1 Spacer and MS3367-5-0 Tie Wrap. Replace damaged or worn parts as required.

4.0 PARTS LIST

QTY -011	PART NUMBER	DESCRIPTION
	DSI 9631-011	VIBRATION ISOLATION INSTL
1	D4713-1	SPACER
1	MS3367-5-0	TIE WRAP

5.0 WEIGHT AND BALANCE

Installation of the DSI 9631-011 Vibration Isolation Kit has negligible effect on Weight and Balance.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY:	D. SHEPHERD (DE # 02)
DATE:	12.09.13
CERT. NO.:	SH11-1
ISSUE NO.:	2

A	NEW ISSUE	AP	12.09.13
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP	DRAWING NO. REV. A	
CHECKED	NA	DSI 9631 SHEET 1 OF 2	
MFG. APPR.	NA	TITLE SCALE	
APPROVED	NA	VIBRATION ISOLATION INSTL NTS	
DE APPR.	NA	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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